Pate

Friday, 04/04/2008 9:21:59 AM

User:

Julie Lecocq

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**  : 38393

: 10993

P.O. Number

This Issue

Prsht Rev.

: 04/04/2008

: NC

: // First Issue

: 37856

S.O. No. :

: MACHINED PARTS Type

Written By

**Previous Run** 

Checked & Approved By

Comment

: Est E est

02.06.17 Now turned on Cobra NG 07.07.06 rev E dwg

EC

**Drawing Name** 

: CROSSBOLT SPACER

**Part Number** 

: D2579 : D2579 REV E

**Drawing Number Project Number** 

: N/A : E

**Drawing Revision** Material

**Due Date** 

: 21/04/2008

Qty:

400 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

1.0

2.0

Machine Or Operation:

M6061T6T0500W058

6061-T6 Tube .500 x.058W

Comment: Qty.:

0.3762 f(s)/Unit

Total: 150.4860 f(s)

6061-T6 Tube .500 x.058W

Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)

0.500 Dia x 0.058 Wall

Batch M107745

HARDINGE CNC LATHE SMALL

Description:

HARDINGE

Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA245

3.0 QC2

PARTS AS THEY COME OFF MACHINE®

QC8 4.0

SECOND CHECK



Comment: SECOND CHECK

5.0

PACKAGING '

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

08/04/18



## **Dart Aerospace Ltd**

W/O:		WORK ORDER CH	ANGES					
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				:				
						:		
Part No		PAR #: Fault Category:	NC	R: Yes	No DQ	A:	Date: _	
				QA:	N/C Close	d:	_ Date: _	<del></del>

	,	WORK ORDI	ER NON-CONFORMANC	E (NCR)					
	Description of NC		Corrective Action Section B						
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Corrective Action Section B Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Description of NC Corrective Action Section B Verification Approval Section A Chief Eng		

NOTE: Date & initial all entries

Date: User: Friday, 04/04/2008 9:21:59 AM

Julie Lecocq

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 38393

Part Number: D2579

Job Number:



Seq. #:

**Machine Or Operation:** 

**Description:** 

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/22

Job Completion



USider

Dart Ae	rospace Li	td								
W/O:			V	ORK ORDER CH	ANGES					
DATE	STEP	PRO	DCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Car	egory:	NC					
						QA: N	/C Close	d:	_ Date: _	
NCR:		'	NORK ORI	DER NON-CONFO	PRMANCE	(NCR	.)			
D.4.T.E	0.750	Description of NC	Corrective Action Section B				Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng			Sign & Date		on C	Chief Eng	QC Inspector
										-1

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38393
Description: Cross Bolt Spacer	Part Number:	D2579
Inspection Dwg: D2579 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype								
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
4.070	+/-0.030	4.073						
0.058	+/-0.010	0.058	V					
					. ,			
					į			

Measured by: MME / SM	Audited by:	-56-	Prototype Approval:	N/A
Date: 08/04/18	Date:	68.001.18	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.27	New Issue	KJ/RF	
В	07.09.06	Dwg Rev updated	KJ/JLM	E
			7 (1	



DESIG	N ##	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECK	KED III	APPROVED	DRAWING NO. REV. E
	-	#	D2579 SHEET 1 OF 1
DATE			TITLE SCALE
 07.0	)4.17		CROSS BOLT SPACER 1:1
Α		96.09.16	NEW ISSUE
В		96.12.05	0.065 WALL WAS 0.035 WALL
O		97.02.21	0.058 WALL WAS 0.065 WALL
D		99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)

UPDATE NOTES



	4.070±0.030
Ø0.500 Ø0.384 (REF)	
0.058	

07.04.17

## D2579 CROSS BOLT SPACER

Ε

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED CCPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDEN

## D2579 CROSS BOLT SPACER

MATERIAL:

6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8

(REF DART SPEC M6061T6T0500W058)

2) FINISH: NONE

3) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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